

Date: Tuesday, 6/26/2007 3:12:17 PM  
 User: Kim Johnston

Process Sheet *BL/JR*

31

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L AFT X-TUBE  
 Job Number : 33161  
 Estimate Number : 10973  
 P.O. Number : *N/A* Part Number : D206667203BL  
 This Issue : 6/26/2007 S.O. No. : *N/A* Drawing Number : D206-667-243 REV B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *NA* Type : LANDING GEAR Drawing Revision : B  
 Previous Run : 33160 Material : *N/A*  
 Due Date : 7/30/2007 Qty: 1 Um: Each  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature] 07.06.27*  
 Comment : Est Rev: 05.09.01 Add holes for compatibility with Bell  
 Skid tubes KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL

*RS 07.07.06* (1)

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG002

*En 07/09/05*

2.0

D6004115

Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6004-115 Crosstube *29114*

Check OD = 2.500"; ID = 1.800"

*BF 07.07.26*

(1)

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA089

2-Turn first side as per Folio FA089

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

*BF 07.07.27* (1)

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

*BF 07.07.27*

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: 206L AFT X-TUBE

Job Number: 33161

Part Number: D206667203BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA089

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243

Inside of Cuff(Donot engrave on outside of tube)

SG 07.07.27

①

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

SG 07.07.27

①

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SG 07/07/27

①

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

Jb 7-7-30

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SG 07/07/30

①

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Jb 7-7-30

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT

EL 7-8-16

PHO →

## WORK ORDER CHANGES

STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/08/15	11.	Tube is over bent	<i>[Signature]</i>	Tube is acceptable AS per. Email from DAVID SHEPHERD. Drill <del>1</del> SADDLE holes at .500" 0.630"	<i>[Signature]</i> 07/08/15	<i>[Signature]</i> 07/08/15	<i>[Signature]</i>	<i>[Signature]</i> 07/08/15

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 33161

Part Number: D206667203BL

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

En 07/08/20

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

SEE DTC on Page  
Page

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243  
Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-667-243.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

JD 7-8-28

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 7-8-28

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JD 7-8-29

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

\* Check holes as per  
Pto

JD 7-8-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 206L AFT X-TUBE

Job Number: 33161

Part Number: D206667203BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 0380r

Issue P/O: 4477

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

*CZ 7/08/290*

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

*P 07/8/30*

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

*Er 07/08/30 (x1)*

20.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate 32777

*RT 07-08-30*

21.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate 32802

*RT 07-08-30*

22.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet 105057

*RT 07-08-30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: 206L AFT X-TUBE

Job Number: 33161

Part Number: D206667203BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install nut plates as per Dwg D206-667-243.

RT 07-08-30

24.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Mask Threaded holes

2-Prime inside and outside crosstube as per Q61-005-4.2

3-Paint outside crosstube DELFLEET BLUE

4-CLEAR WITH DELFLEET

ISSUE P.O TO ATELIER DEBOSELAGE

4505 C26708131 @ 6/26/07

25.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

RT 07-09-04

26.0

D2856400

Abrasion Strip



Comment: Qty.: 1.3525 f(s)/Unit Total : 1.3525 f(s)

Pick:

Qty Part number Description

Batch

2 D2856-400(Cut to 7.73")

Abrasion Strip

32992

32992

RT 07-09-04

27.0

D28921

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description

Batch

2 D2892-1

Support

34148

34148

RT 07-09-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 33161

Part Number: D206667203BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

MS2192022

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22

Clamp

~~104722~~

104722

ST 07 09 04

29.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8580. Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

ST 07-09-04

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 01/08/05

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

32.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M102850

LC

33.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M104847

LC

34.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

M105144

LC

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   D   Date:   9/09/05    
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 33161

Part Number: D206667203BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

10 AN5-10A

Bolt

35.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-32A

Bolt

M102850

36.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

M104156

PU 7/9/05 (1)

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

En 07/09/05

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-203

Location:

PPP Rev:

C 07/09/05

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/05 (1)

Job Completion



U 07/05

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	33161
<b>Description:</b> Crosstube Assembly		<b>Part Number:</b>	D206-667-243
<b>Inspection Dwg:</b> D206-667-243 <b>Rev:</b> B		<b>Page 1 of 1</b>	

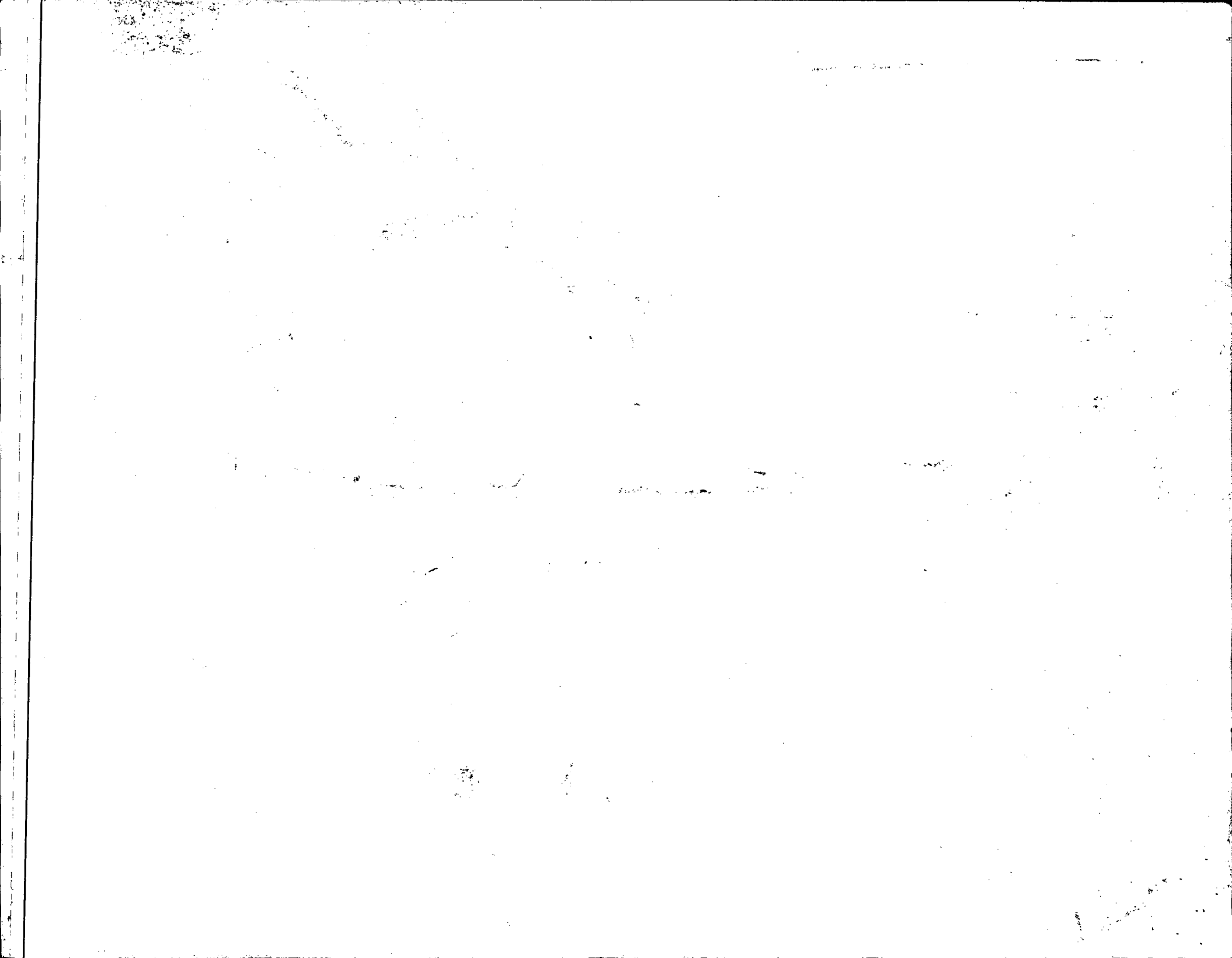
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.492	✓		
	2.018	+0.005/-0.000	2.022	✓		
	2.079	+0.005/-0.000	2.084	✓		
	2.145	+0.005/-0.000	2.150	✓		
	2.209	+0.005/-0.000	2.214	✓		
	2.287	+0.005/-0.000	2.292	✓		
	2.363	+0.005/-0.000	2.368	✓		
	2.433	+0.005/-0.000	2.438	✓		
	0.200	+/-0.010	.200	✓		
	0.500 x 30°	+/-0.010	.500	✓		
	R0.063	+/-0.010	.063	✓		
	R0.500	+/-0.010	.500	✓		
	4.438	+/-0.030	4.438	✓		
SIDE B	104.91	+/-0.020	104.91	✓		
	2.490	+0.005/-0.000	2.492	✓		
	2.018	+0.005/-0.000	2.022	✓		
	2.079	+0.005/-0.000	2.084	✓		
	2.145	+0.005/-0.000	2.150	✓		
	2.209	+0.005/-0.000	2.214	✓		
	2.287	+0.005/-0.000	2.292	✓		
	2.363	+0.005/-0.000	2.368	✓		
	2.433	+0.005/-0.000	2.438	✓		
	0.200	+/-0.010	.200	✓		
	0.500 x 30°	+/-0.010	.500	✓		
	R0.063	+/-0.010	.063	✓		
	R0.500	+/-0.010	.500	✓		
	4.438	+/-0.030	4.438	✓		

<b>Measured by:</b>	BG	<b>Audited by:</b>	mf	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	07.07.27	<b>Date:</b>	07/07/27	<b>Date:</b>	N/A

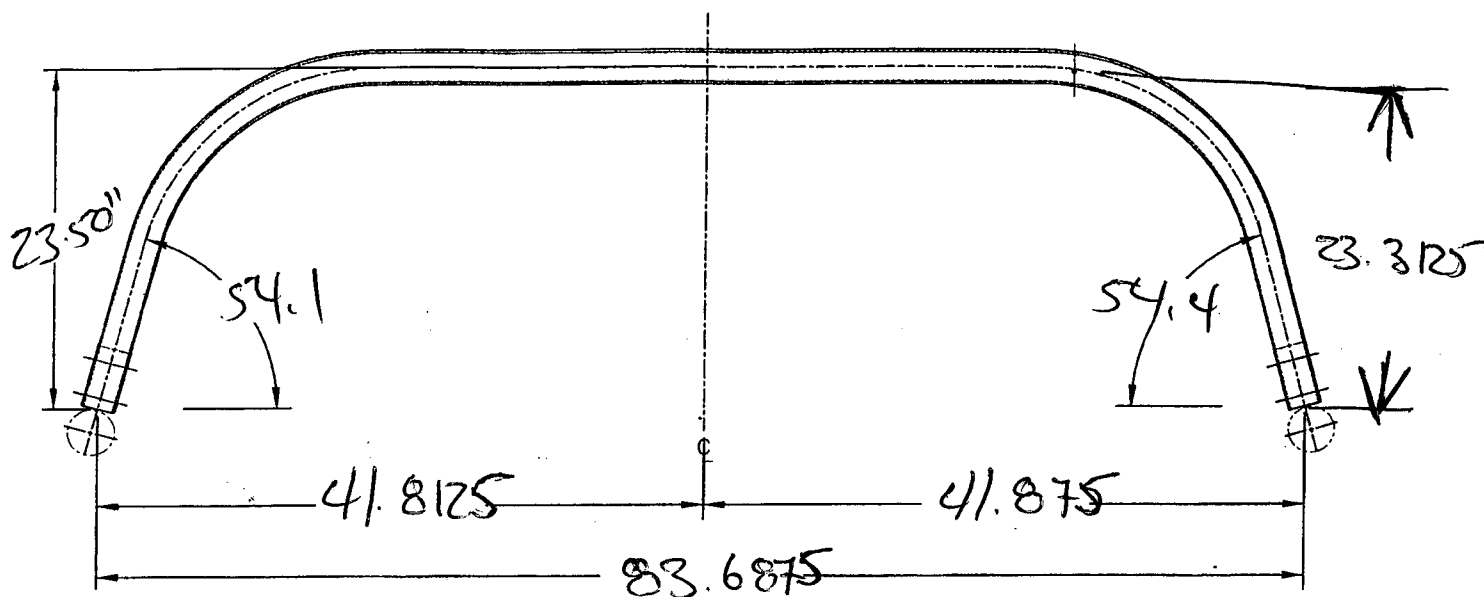
Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue (P/O D206-667-203)	KJ/JLM	





DART AEROSPACE LTD		Work Order:	33161
Description: Crosstube High Aft (206L)		Part Number:	D206-667-203
Inspection Dwg: D206-667-243 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments
* See E-mail from David Shenker
* Drill holes at

QC15 Inspection	Er.
Date	07/08/20

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	[Signature]



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED DS	DRAWING NO. D206-667-243	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED  
05-07-26

UNDER REVIEW

06-07-10 RH

12 draw detail F

RH

07-05-02

Qty	Part Number	Description
X	D206-667-243	CROSSTUBE ASSEMBLY
1	D6004-115	CROSSTUBE
2	D2856-400-773	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2892-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-22	CLAMP

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6004-115  
FINISHED LENGTH = 104.91±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2892-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

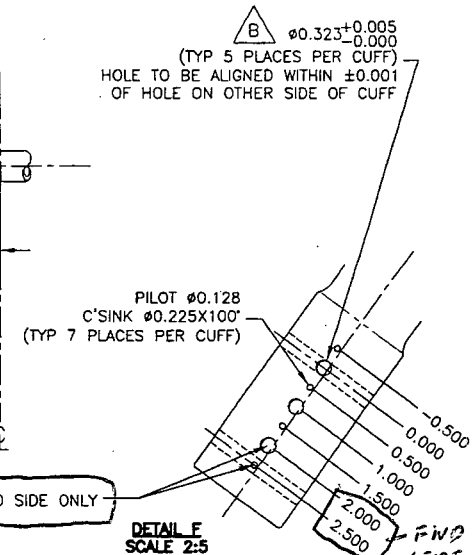
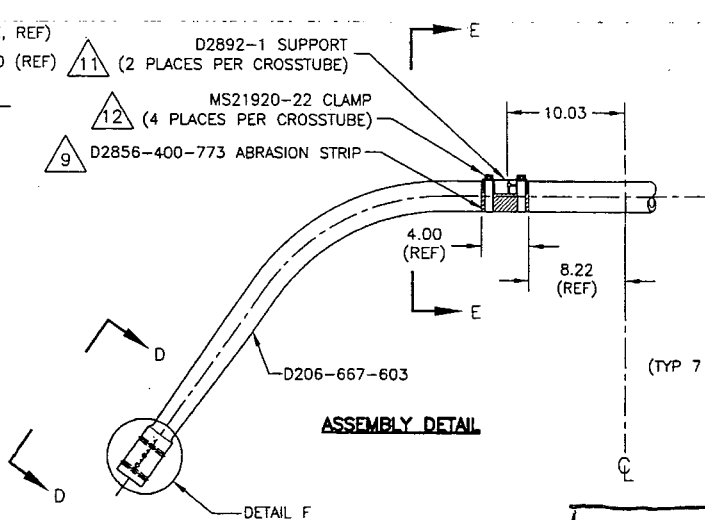
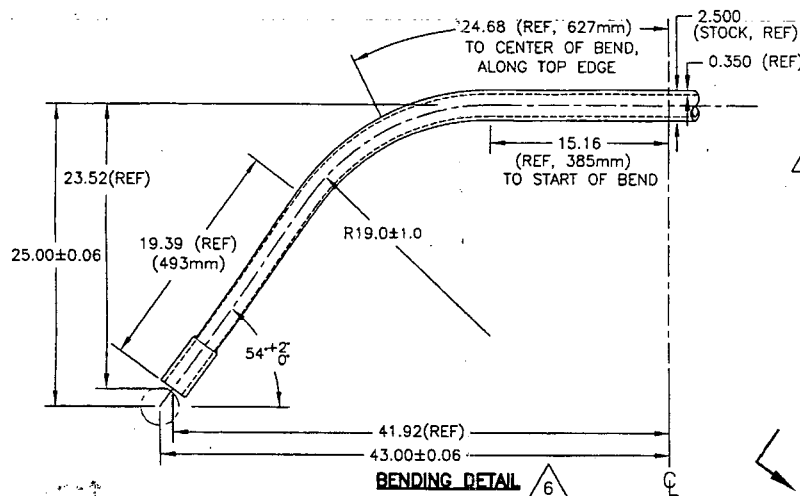
WORK ORDER

NO. 33161

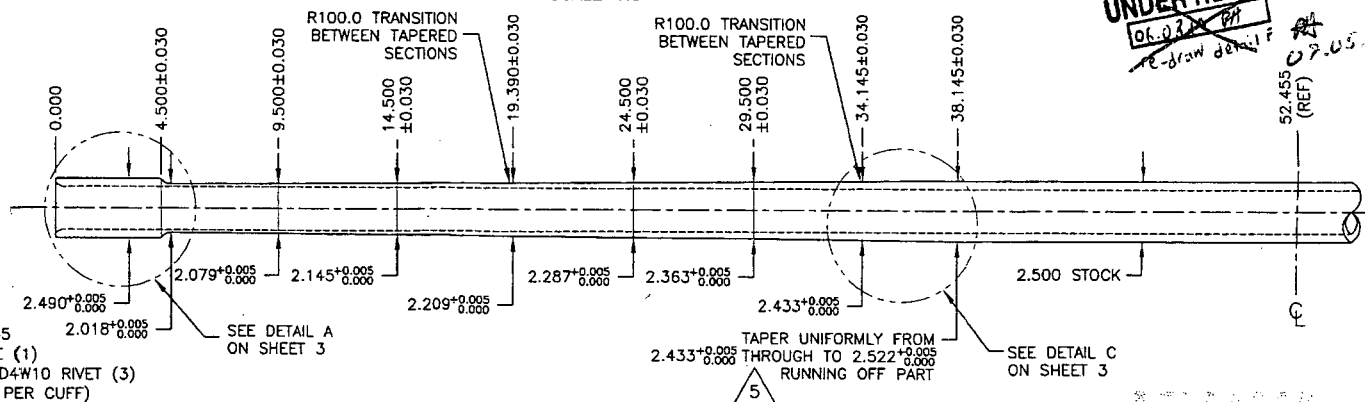
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**TURNING DETAIL SCALE 1:5**

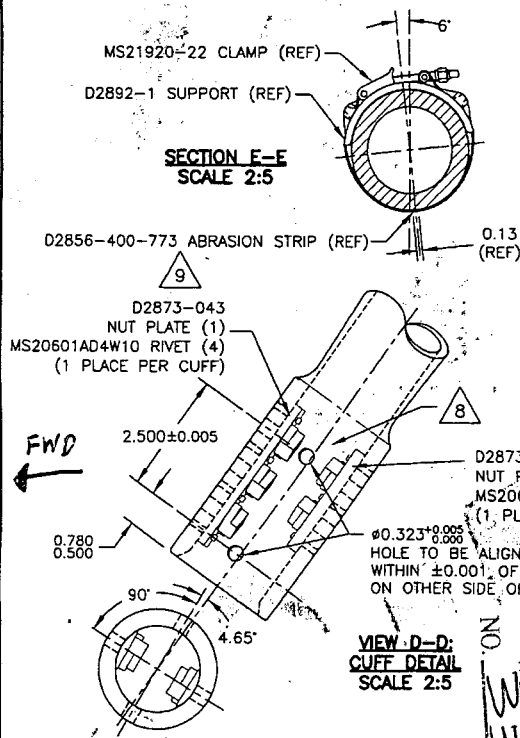


**UNDER REVIEW**

06.03.26 PH

re-draw detail F

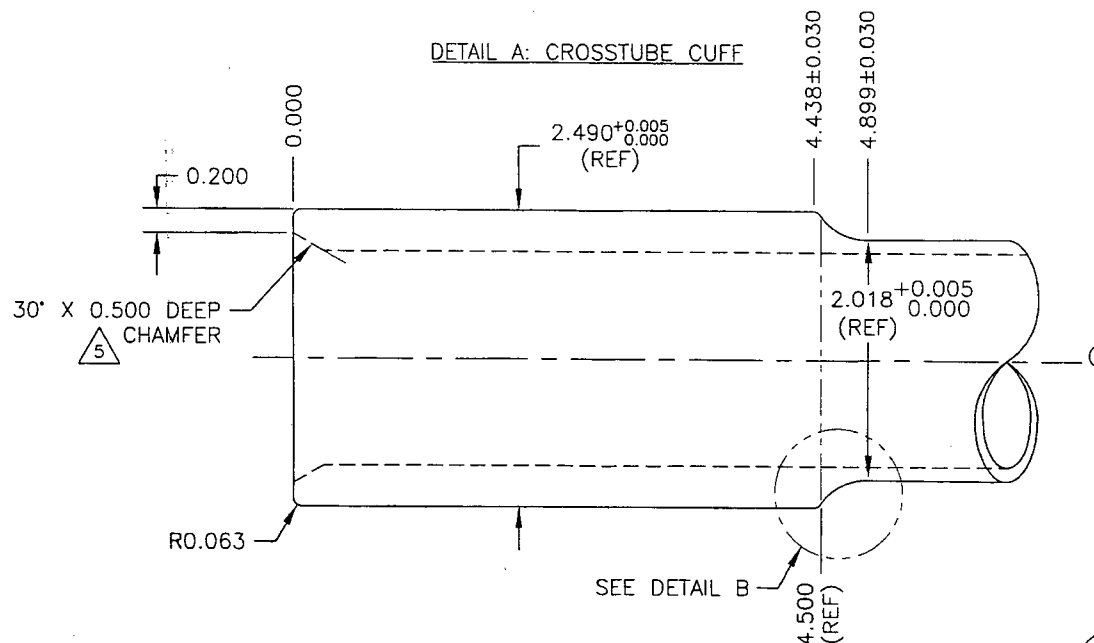
05.07.26



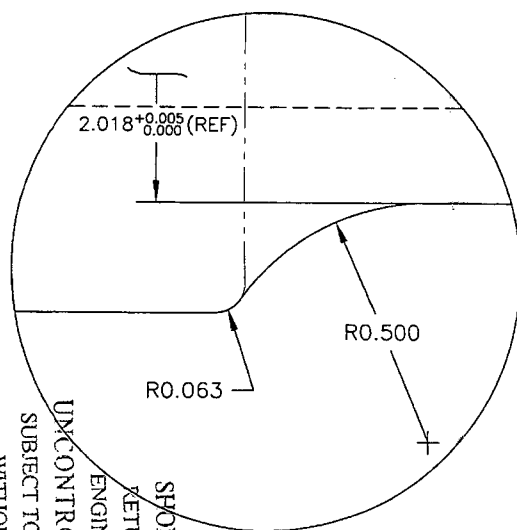
SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33161

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DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT)		SCALE 1:10	

# DETAIL A: CROSSTUBE CUFF

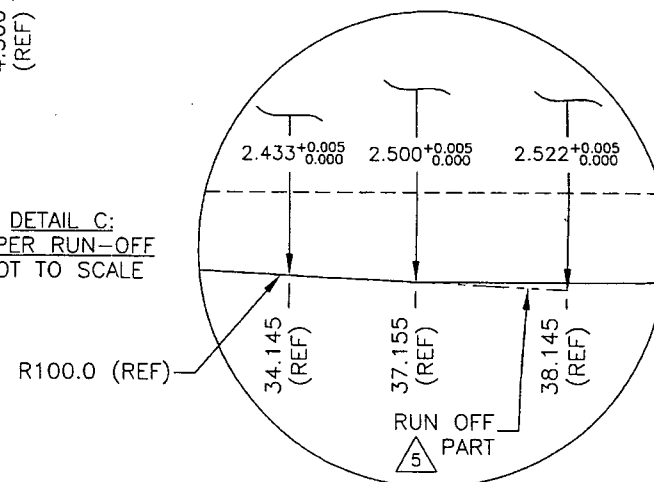


05.07.26 #  
**UNDER REVIEW**  
~~06.05.06 PH~~  
Re-draw detail F  
PH 07.05.02



DETAIL B: CUFF  
TRANSITION  
SCALE 4:1

DETAIL C:  
TAPER RUN-OFF  
NOT TO SCALE



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DRAWN BY

PH

**DART**

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MARKHAM, ONTARIO, CANADA

CHECKED

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DS

DRAWING NO.

D206-667-243

REV. B

SHEET 3 OF 3

DATE

05.07.26

TITLE

CROSSTUBE ASS'Y (206L HIGH AFT)

SCALE

1:1

NO. 33161  
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**Jason Murdoch**

**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** Saturday, August 18, 2007 2:05 AM  
**To:** 'Jason Murdoch'; davids@dartaero.com  
**Cc:** 'Jean-Luc Menard'; 'L Lacelle'  
**Subject:** RE: D206-667-203/B33161 and D206-667-103/B33155

D206-667-203 B33161 and D206-667-103 B33155 are both acceptable deviations per the dimension sheets that you sent me.  
D206-667-203 B33161 needs to be drilled so that the top of the tube will be level when it is installed.

David

**From:** Jason Murdoch [mailto:jmurdoch@dartaero.com]  
**Sent:** Friday, August 17, 2007 9:51 AM  
**To:** davids@dartaero.com; David Shepherd  
**Subject:** D206-667-203/B33161 and D206-667-103/B33155

Morning David Its Eric Downing again.

I have two cross tubes with some questions?

The 206-667-203/B33161 has the heights of from one side to another by .1875

The 206-667-103/B33155 has the height off by 0.060thou.

What is your opinion about these?

Thanks

Eric Downing

jmurdoch@dartaero.com

Q.C. COORDINATOR

**From:** Marc Bellavance [mailto:mbellavance@dartaero.com]  
**Sent:** Friday, August 17, 2007 11:12 AM  
**To:** 'Jason Murdoch'  
**Subject:** CROSSTUBES

**Marc Bellavance**  
**Internal Support/Product Improvement**

**DART** aerospace Ltd.

Tel: 613-632-5200 Ext. 240

Fax: 613-632-9311

E-mail: mbellavance@dartaero.com

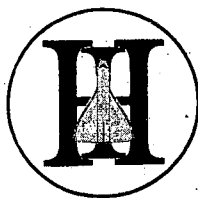
Web: www.dartaero.com

No virus found in this incoming message.

Checked by AVG Free Edition.

Version: 7.5.484 / Virus Database: 269.12.0/959 - Release Date: 8/17/2007 5:43 PM

8/20/2007



# HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 37260

A.M.O. Number: 46/90

## NON-DESTRUCTIVE TESTING REPORT

### AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

### INSPECTION REQUIREMENTS

Carry out FPI of (6) cross tubes (external surface) as per ASTM E-1417-05 and the Dart OSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (3) P/N D206-667-103 S/N's B32141, B33683 and B33684.

Qty (2) P/N D206-667-203 S/N's B33688 and B33161.

Qty (1) P/N D206-667-103BL S/N B33155.

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

### INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (6) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive) Ardrex 970P25E Batch #04B503.

(6) cross tubes inspected. (6) PASSED / (0) FAILED.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

*[Signature]*  
DL HEATH

DATE August 29, 2007

INSPECTION  
STAMP(S)

*[Signature]*

### CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER PO 0000477

ADDRESS:

CONTACT NAME: Linda Lacelle

LABOUR @  
MATERIALS @  
TRAVEL EXPENSES @  
HOTEL EXPENSES @

\$

GST

PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT